Work Orde									:	Page 1
Item ID: Revision ID: Item Name:	D3907-1 Bushing			Accept		11 11 11 11 12		_ !	Start Stop	
Start Date: Required Date: Reference:	7/1/2010 7/12/2010	Start Qty: 40.00 Req'd Qty: 40.00	1 (2011) 8161/ 8161/ 1616 1 (2011) 8161/ 861/ 161		Cust Ite			: : !		
Approvals:	Process Pla	n:	Date: 10-7-01 Date:	Tooling: SPC (Y/N):		Date:	- -		Ston	18:18:18:18:18:18:18:18:18:18:18:18:18:1
Sequence ID/ Work Center ID Draw Nbr		Operation Description ision Nbr		Set Up/ Run Hours	Tool II	Tool# Plan Code	Accept Qty	Rejec Qty		Insp. Stamp
D3907 100 Hardinge CNC Lathe	A Small	Memo Machine as & Dwg D39 Dwg Rev: folio Rev: Deburr	per Folio FA823	0.00	107/15	40	>			
10 QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00	4/15	•				,

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	Johan	,								•
W/O:			W	ORK ORDER CHANGE	ES					· •
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			•			-				
			Fault Category: NCR: Ye			: Yes	No DQ	ļ		
			Disposition: QA			N/C Clo	sed:			
NCR:			WORK ORI	DER NON-CONFORMA	NCE	(NCR)			
DATE	STEP	Description of NC Corrective Action			Section B Verifi			ation	Approvai	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		n C	Chief Eng	QC Inspector
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Work Order ID 60273 Thursday, July 01, 2010 8:49:18 AM Item ID: Page 2 D3907-1 Revision ID: | 1881|| 181 | 181 | 181 | 181 | 181 | 181 | 181 | 181 | 181 | 181 | 181 | 181 | Accept Setup Start Item Name: Bushing **Start Date:** 7/1/2010 **Start Qty: 40.00** Stop Required Date: 7/12/2010 Req'd Qty: 40.00 Cust Item ID: Reference: **Customer:** Approvals: Process Plan: _____ Date: ____ Tooling: Run QC:____ Start Date: Date: SPC (Y/N): Stop Sequence ID/ Date: Operation Work Center ID Set Up/ Description Tool ID Tool # Plan 120 Accept **Run Hours** Reject Reject QC8- Inspect parts - second check Insp. Code Qty 0.00 Qty Number Stamp QC Memo Quality Control 40 130 Identify as per dwg & Stock Location: Basket ull 0.00 Packaging SM 10/07/16 6 Memo Packaging 0.00 140 QC21- Final Inspection - Work Order Release 0.00 Memo Quality Control 0.00 MF 10-7-16

W/O:		WORK ORDER CHANGES								•
DATE	STEP	PROC	CEDURE CH	ANGE	Ву	Date	Q	у	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	_ Fault Cat	tegory:	NCR: Yes	No DQA	۱:		_ Date:	. <u>-</u> .
	R	esolution:	solution: QA: N/C Closed						_ Date: _	
NCR:	**************************************	WORK ORDER NON-CONFORMANCE (NCR)								
		Corrective Action Section B								
DATE	STED	Description of NC				Verific			Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	B Sign Date	& Section			Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A		Action Description	Sign	& Section				
DATE	STEP	Description of NC Section A		Action Description	Sign	& Section				
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DATE	STEP	Description of NC Section A		Action Description	Sign	& Section				
DATE	STEP	Description of NC Section A		Action Description	Sign	& Section				
DATE	STEP	Description of NC Section A		Action Description	Sign	& Section				

Picklist Print

Thursday, July 01, 2010 8:51:23 AM

Work Order ID: 60273

Parent Item: D3907-1

Parent Item Name: Bushing



Start Date: 7/1/2010

Start Qty: 40.00

Loc Code

Required Date: 7/12/2010

Page 1

Required Qty: 40.00

Com	ments:	,
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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on	Qty per Kit	Total	Qty	Date	
M304R0.375 304 ROUND BAR 0.375	1	Purchased	No		100	f	Hand 19.9400	0.03	Qty 1.2	Issued	Issued	Status

Location Loc Oty MAT 14.6 0 5.1 9.5 MAT029 5.34 3.85 1.49 115180

JL 10/07/15

	WORK ORDER CHANGES								
TEP	PRO	OCEDURE CH	ANGE		Ву	Date	Cty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			-						
	PAR #:	Fault Cat	egory:	NCR	:Yes N	No DQA	:	_ Date: _	
						sed:		Date: _	
NCR:			DER NON-CONFORM	ANCE	(NCR)				
TEP	Description of NC	In tale 1	tion B	— verifica			Approval	Approval	
	Section A	Chief Eng	Chief Eng		Date	Sectio	r C	Chief Eng	QC Inspector
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1									
			- 						
		PAR #:PAR #: Resolution:	PAR #: Fault Cat Resolution: Disposition WORK ORE TEP Description of NC Section A Initial Chief Eng	PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORM TEP Description of NC Section A Chief Eng Chief Eng Chief Eng Chief Eng	PAR #: Fault Category: NCR Resolution: Disposition: QA: WORK ORDER NON-CONFORMANCE TEP Description of NC	PAR #: Fault Category: NCR: Yes North	PAR #: Fault Category: NCR: Yes No DQA Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) TEP Description of NC Section A Chief Eng Corrective Action Section B Sign & Date Chief Eng	PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) TEP Description of NC Section A Chief Eng Ch	PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) TEP Description of NC

DART AEROSPACE LTD		
STATE ALKOOPAGE LID	Work Order:	(1272
Description: Bushing		002/
	Part Number:	D3907-1
Inspection Dwg: D3907 Rev: A		
		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

D		ANTICLE	SPECIA	ON CH	CKLIST	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	0.343	-	 -	**************************************	
0.25	+/-0.030	-254	1		 	
0.059	+/-0.010	- 234			ļ	
Ø0.257	+0.006/-0.001	0.2			ļ <u>.</u>	
	313007 3.001	6,760				
						7
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asured by:	Au	dited by:	1		reliminary A	
Date: 10	3/14	Date: 13	110		reliminary App	
Date Cha	<u> </u>	- Jule. 10/C	7/11			Date:

Rev	Date	Change		
A	09.05.20	New Issue	Revised by	Approved
B	10.06.07	Tolerance for dimension Ø0.375 revised	KJ	
		Do. of o Tevised	KJ 🙀	77

Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr QC Inspector

Part No: _		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolutio	:	Disposition:	QA: N/C Closed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Section B				Approval			
STEP	Section A	Initial Chief Eng			Section C	Chief Eng	QC Inspector			
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Initial Action Description	STEP Description of NC Corrective Action Section B Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Corrective Action Section B Verification Approval Section A Chief Eng			

SHOP COPY D RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER Ø0.375 0.059 REF Ø0.257 **D3907-1 BUSHING** SECTION A-A C5-1 NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R OR: AISI 304/316 STAINLESS STEEL BAR REF DART SPEC M304B NEW ISSUE REV. 2) FINISH: NONE AJS 09.03.11 DESCRIPTION 2) FINISH: NUNE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX DESIGN BY DATE DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN [CHECKED 6) IDENTIFICATION: N/A DRAWING NO MFG. APPR. 7) WEIGHT: N/A D3907 REV. A APPROVED SHEET 1 OF 1 TITLE DE APPR. BUSHING (BASKET REPAIR) SCALE DATE COPYRIGHT © 2009 BY DART AEROSPACE LTD

IS DOCK AT IS TRUSTED OF THE THE THE STREET OF 09.03.11

W/O:			٧	VORK ORDER CHAN	GES		<u> </u>			• ,
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		N .								
Part No	•	PAR #: <u>***</u>	_ Fault Ca	tegory:	NCR	: Yes N	lo DQA:		Date:	
	R	esolution:	_ Disposit	ion:	QA:	N/C Clo	sed:	1	Date: _	
NCR:		W	ORK OR	DER NON-CONFORM	IANCE	(NCR)				
DATE	STEP	Description of NC			ection B	Cian 9	Verifica	ton		Approval
DAIL	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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